

Work Order ID 147215

Thursday, June 23, 2016 8:37:48 AM

147215

Page 1

Item ID: 647.7813

Revision ID:

Item Name: Center Plate, Lower

Start Date: 6/7/2016 Start Qty: 6.00

Required Date: 7/4/2016 Req'd Qty: 6.00

Reference:

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: MCS Date: JUN 23 2016

QC: _____ Date: _____ SPC (Y/N): _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
647.7800	A

100	BAND SAW	0.00				10	Ø		DAS 44 9-89 16-06-23
100									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blank at 3.375"								

110	HAAS CNC VERTICAL MACHINING #1	0.12							DAS 44 9-89 16-06-24
110									
HAAS 1	Memo	0.22							
HAAS CNC vertical machine #1	1-Machine per folio FB236 DWG REV: <u>A</u> FOLIO REV: <u>N/C</u>								

2- deburr and break all sharp edges

Work Order ID 147215

Thursday, June 23, 2016 8:37:48 AM

147215

Page 2

Item ID: 647.7813

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Center Plate, Lower

Start Date: 6/7/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/4/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 44 9-89
120						10			16-06-24
QC	Memo	0.01							
Quality Control									
130	QC8- Inspect parts - second check	0.00							DAS 14 9-89
130						10	0		16/06/28
QC	Memo	0.02							
Quality Control									
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							DAS 13 9-89
140						10			JUL 08 2016
Outsource4	Memo	179.99							
Outsource process - Anodize	Issue P/O to ATG : <u>32971</u>								
	1- Black Anodize as per Dwg 647.7800								
	2- PRIME AS PER DWG, SEE NOTE #2								
	Certification of Comformity is required								

Work Order ID 147215

Thursday, June 23, 2016 8:37:48 AM

147215

Page 3

Item ID: 647.7813

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Center Plate, Lower

Start Date: 6/7/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/4/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Receive & Inspect for Damage & Mat'l Certs

0.00

150

Packaging

Memo

0.02

Packaging

10x Sp/6-7-12

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.02

Quality Control

10DAS
38
9-89

JUL 20 2016

180

Identify as per dwg & Stock Location: CK114 0.00***180***

Packaging

Memo

0.01

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

10DAS
38
9-89

JUL 21 2016

Picklist Print

Thursday, June 23, 2016 8:37:51 AM

Page 1
/

Work Order ID: 147215

147215

Parent Item: 647.7813

647 7813

Parent Item Name: Center Plate, Lower

Start Date: 6/7/2016

Required Date: 7/4/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV A 14/01/07 VERIFIED BY DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B0.750X4.000		Purchased			No	100	f	15.4830	0.281	1.774737			
M7075T6B0 750X4 000													
7075-T6 BAR 0.750" X 4.000"													

DAS
44
9-89

16-06-23

Location

Loc Qty

Loc Code

MAT005

15.483

~~N~~m127860

3.483

m133589

12

2.962

CUT BLANKS AT 3.375"

1 2 3 4 5 6 7 8

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	LAST PRELIMINARY RELEASE: PRE2		NG
2	INITIAL RELEASE	12/21/09	P. BRAVO
3	INCORPORATED ECH G3128, 04407, & 05125	03/02/10	P. BRAVO

NOTES:

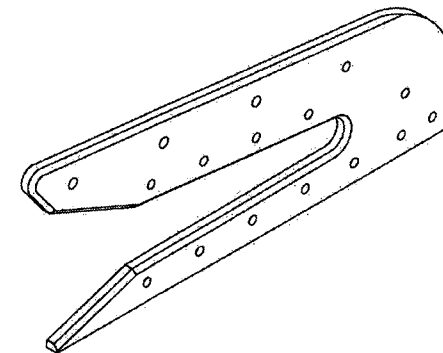
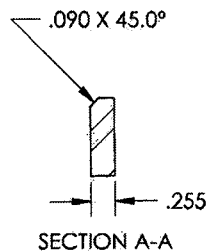
- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH IAW MPP-172 SECTION 3.3 & 4.3.
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 143215 MLS
1606-23

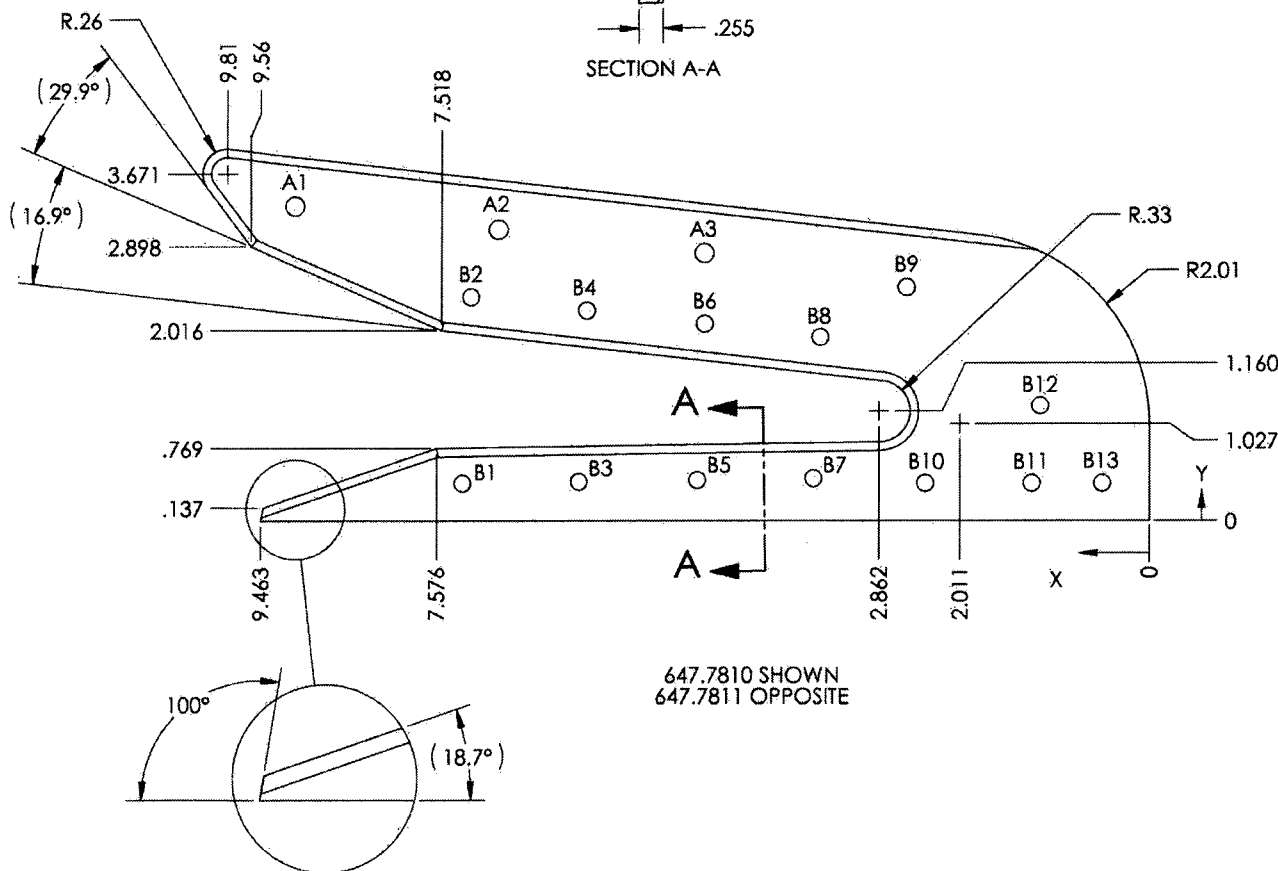
	647.7823	CROSS BRACKET AFT	△	△
	647.7822	EYE BOLT FITTING RH	△	△
	647.7821	EYE BOLT FITTING LH	△	△
	647.7820	CROSS BRACKET AFT	△	△
	647.7819	CROSS BRACKET FWD	△	△
	647.7818	MOUNTING CHANNEL	△	△
	647.7817	AFT BRACKET	△	△
	647.7816	AFT BRACKET	△	△
	647.7815	FORWARD BRACKET	△	△
	647.7814	FORWARD BRACKET	△	△
	647.7813	CENTER PLATE LOWER	△	△
	647.7812	CENTER PLATE UPPER	△	△
	647.7811	BRACKET B	△	△
	647.7810	BRACKET A	△	△
	F/N	PART #	DESCRIPTION	MAT'L .SPEC

QTY		PARTS LIST	
NEXT ASSY (S)		ORIGINAL DATE: 11-05-09 DRAWN BY: E. ANDERSON P. BRAVO DRAWING APPROVAL: P. BRAVO CONTRACT NO.:	
647.7300		DART 3030 ENTERPRISE CT., SUITE A AEROSPACE VISTA, CA. 92081 APICAL INDUSTRIES, INC. (760)-724-5300 DBA DART AEROSPACE	
		BRACKET	
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.2°		SIZE: B CAGE CODE: 07M26 SCALE: NONE	DWG. NO: 647.7800 REV. A SHEET 1 OF 10

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647.7810
647.7811 OPPOSITE

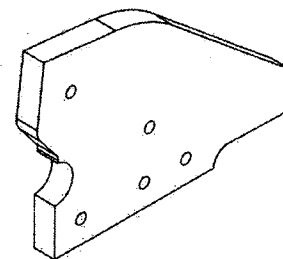


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A2	6.906±.002	3.083±.002	Ø.201 THRU
A3	4.720	2.835±.002	Ø.201 THRU
B1	7.300±.002	.397±.002	Ø.177 THRU
B2	7.203±.002	2.369±.002	Ø.177 THRU
B3	6.050±.002	.415±.002	Ø.177 THRU
B4	5.961±.002	2.228±.002	Ø.177 THRU
B5	4.800±.002	.433±.002	Ø.177 THRU
B6	4.719±.002	2.088±.002	Ø.177 THRU
B7	3.550	.450	Ø.177 THRU
B8	3.476	1.947	Ø.177 THRU
B9	2.575	2.475	Ø.177 THRU
B10	2.380	.400	Ø.177 THRU
B11	1.250	.400	Ø.177 THRU
B12	1.160	1.220	Ø.177 THRU
B13	.500	.400	Ø.177 THRU

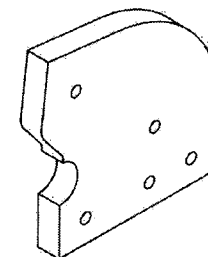
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DRAWN BY L. ANDERSON	CHECKED BY P. BRAY	DART AEROSPACE APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAY 11-25-04 CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS .001 THREE DECIMALS .005 ANGLES .5°		REV. B 07M16 SCALE NONE	DWG. NO. 647.7800 SHEET 2 OF 10

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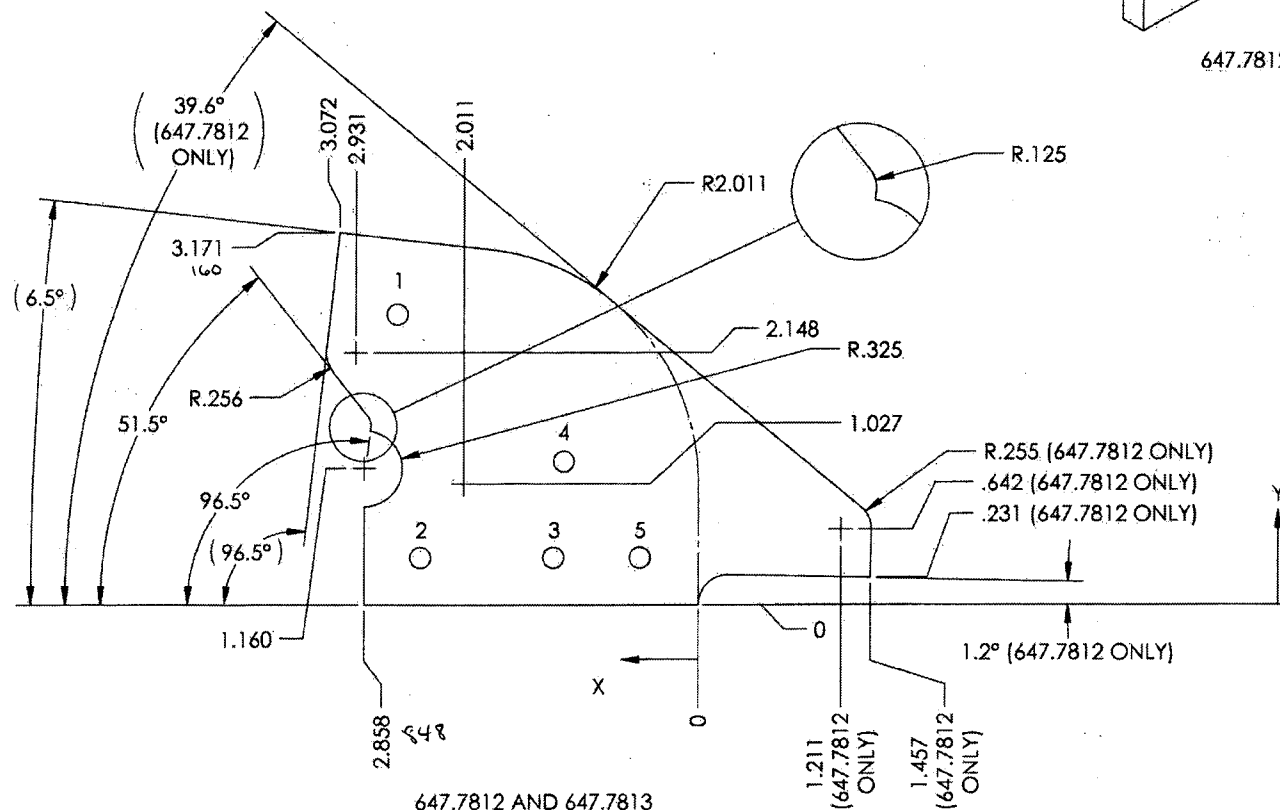
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5	.500±.002	.400±.002	Ø.177 THRU



647.7812

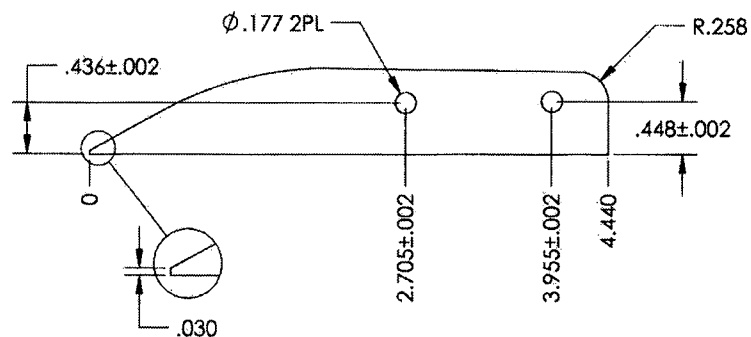
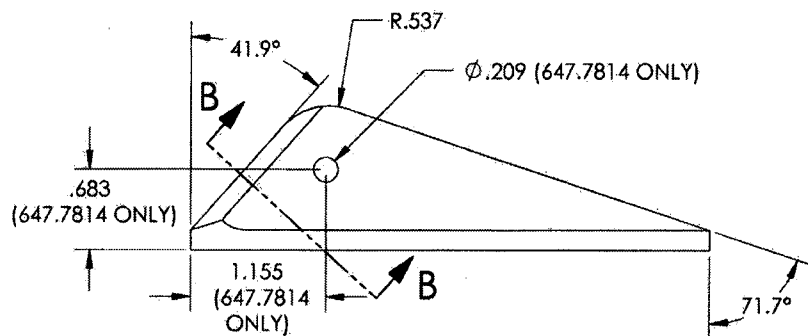
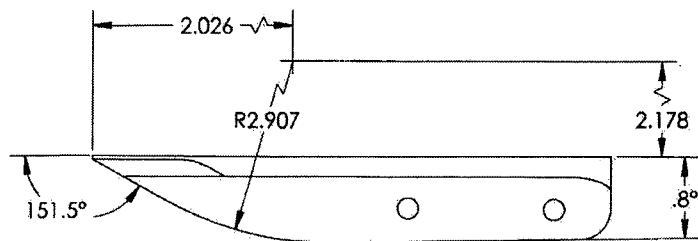


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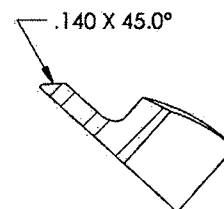
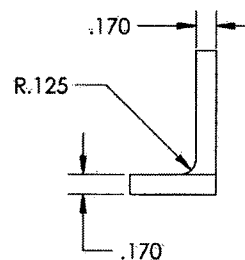


ORIGINAL DATE 11-05-09		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E. ANDERSON P. BRAVO		DART AEROSPACE	
DRAWING APPROVAL P. BRAVO		APCAL INDUSTRIES INC. DART AEROSPACE	
CONTRACT NO.		BRACKET	
SHEET B	CAGE CODE 07M2G	DWG. NO. 647.7800	REV. A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		SCALE NONE SHEET 3 OF 10	

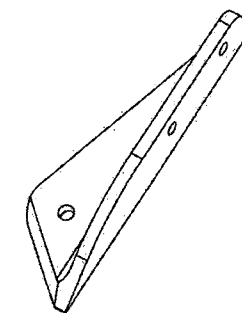
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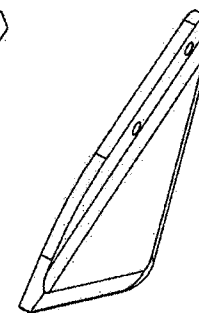
647.7814 SHOWN
647.7815 OPPOSITE



SECTION B-B



647.7814



647.7815

ORIGINAL DATE: 11/05/05
DRAWN BY: J. ANDERSON
DRAWING APPROVAL: J. BRAVO
CONTRACT NO.

DART AEROSPACE
3030 ENTERPRISE CT., SUITE A
VISTA, CA 92081
(760) 724-5300
APICAL INDUSTRIES, INC.
DBA DART AEROSPACE

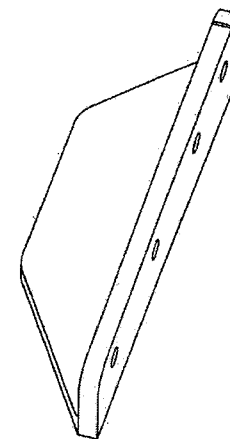
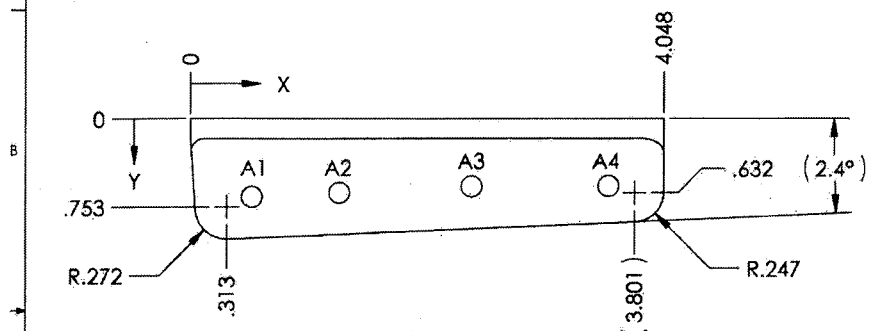
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UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
1 PLACE DECIMALS ±.01
2 PLACE DECIMALS ±.005
ANGLES ±.5°

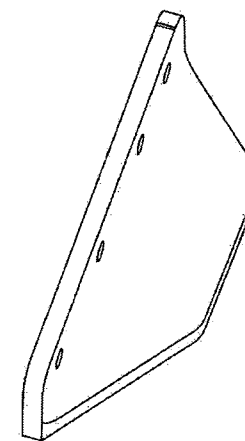
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B	07M26	647.7800	A
SCALE: NONE		SHEET: 4 OF 10	

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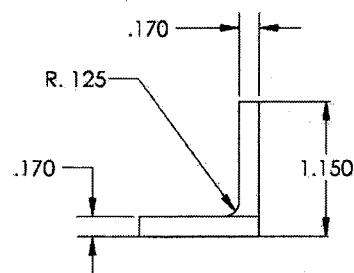
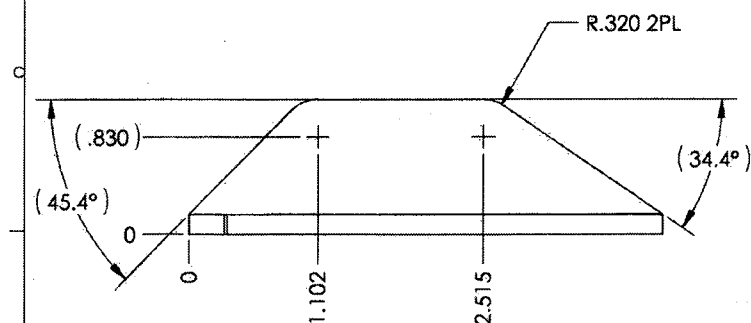
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647.7816



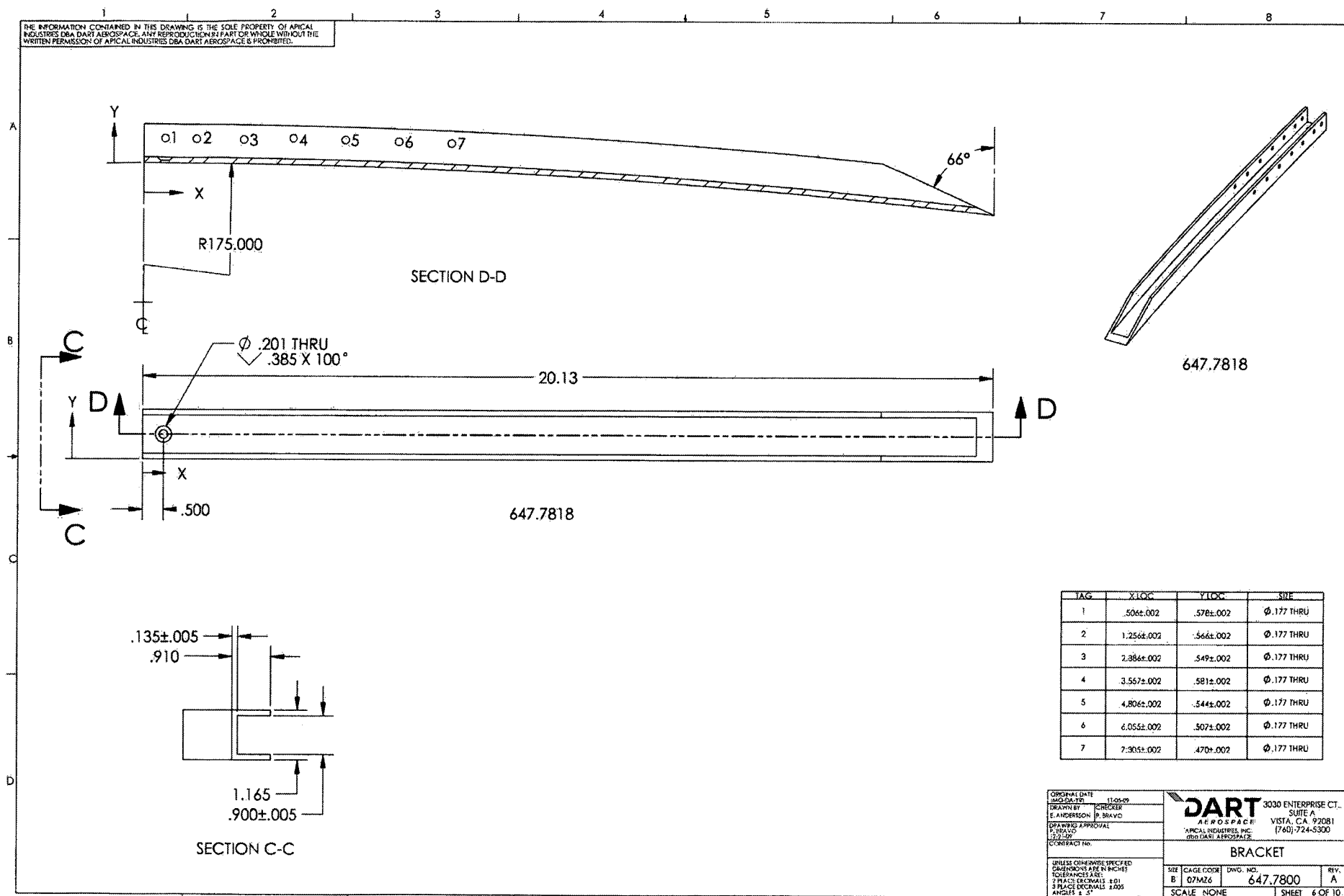
647.7817



647.7816 SHOWN
647.7817 OPPOSITE

ORIGINAL DATE (MM/DD/YY)	11/05/09	 DART AEROSPACE ANCAL INDUSTRIES INC. 3030 ENTERPRISE CT., SUITE A VISTA, CA, 92081 (760)-724-5300 FAX: 760-724-5300	
DRAWN BY	CHECKER		
DATE	11/05/09		
DRAWING APPROVAL			
BY			
CONTRACT NO.		BRACKET	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES			
2 PLACE DECIMALS ± .01			
3 PLACE DECIMALS ± .001			
ANGLES ± .01			
SRC	CAGE CODE	DWG. NO.	REV.
B	07M26	647.7800	
SCALE		NONE	
		SHEET 5 OF 10	

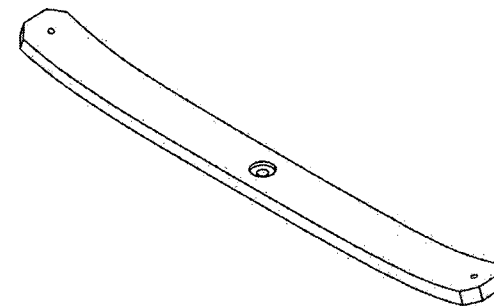
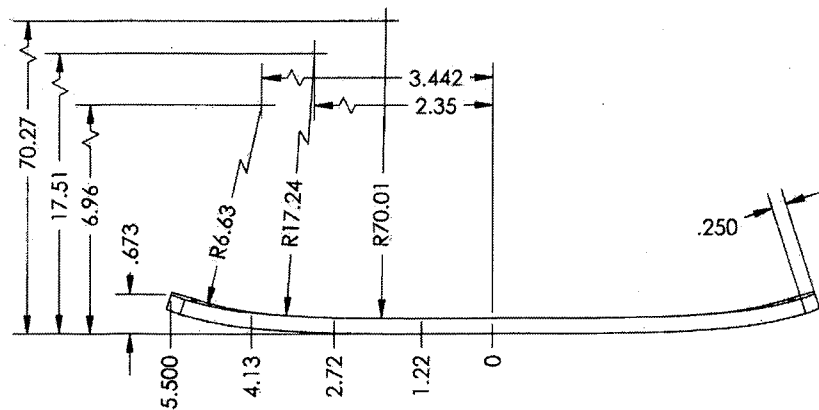
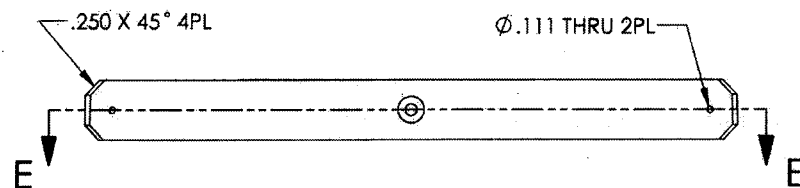
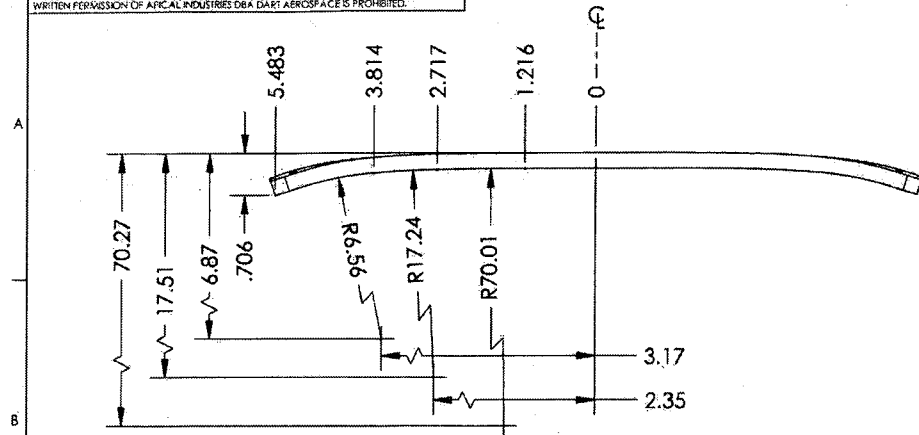
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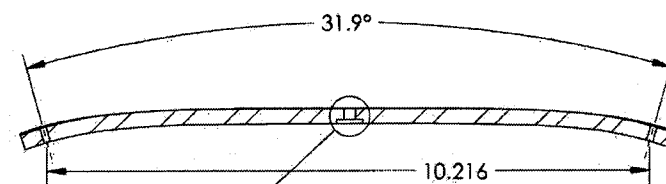
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6	6.055±.002	.507±.002	Ø.177 THRU
7	7.305±.002	.470±.002	Ø.177 THRU

ORIGINAL DATE 11-05-09		DRAWN BY E. ANDERSON		CHECKED BY P. BRAVO	
DRAWING APPROVAL P. BRAVO 11/12/09		CONTRACT NO.			
DART AEROSPACE APICAL INDUSTRIES, INC. (DBA DART AEROSPACE) 3030 ENTERPRISE CT., SUITE A VISTA, CA 92081 (760) 724-5300					
BRACKET					
SIZE B	CAGE CODE 07M26	DWG. NO. 647.7800	REV. A		
SCALE NONE			SHEET 6 OF 10		

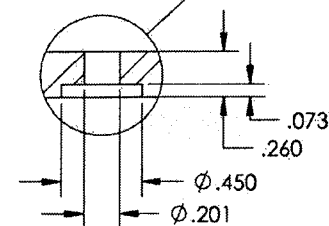
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647.7819



SECTION E-E



ORIGINAL DATE
11/05/07
DRAWN BY
L. ANDERSON / P. BRAVO
DRAWING APPROVAL
P. BRAVO
11/21/07
CONTRACT NO.

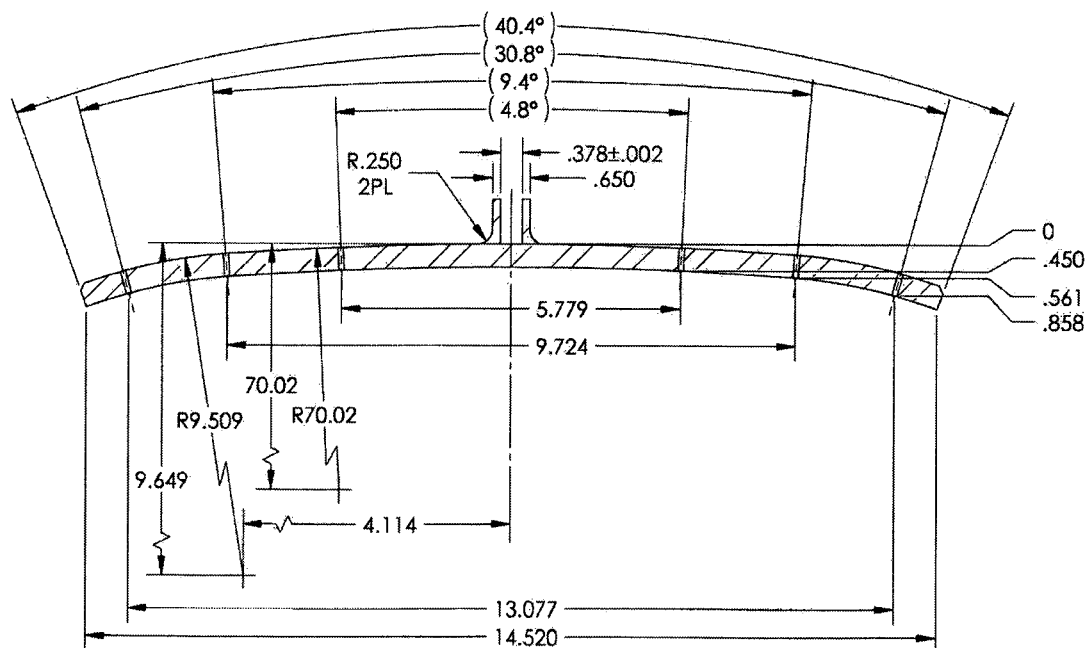
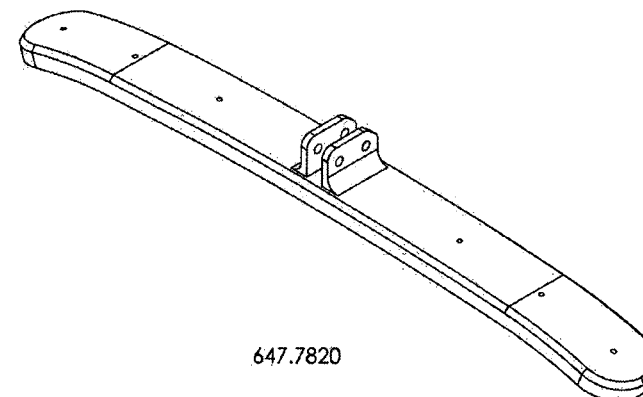
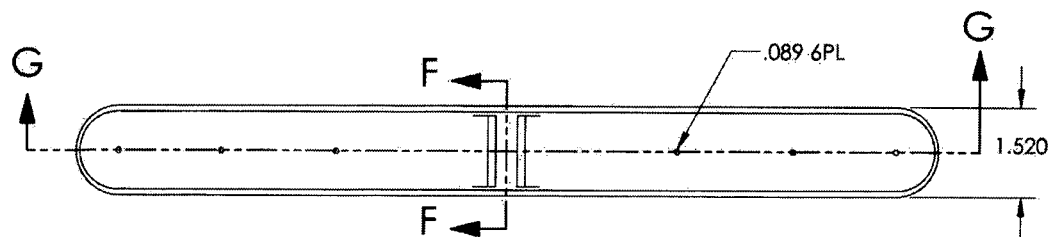
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ± 5°

DART 3030 ENTERPRISE CT.,
AEROSPACE SUITE A
VISTA, CA 92081
(760) 724-5300
APICAL INDUSTRIES, INC.
DBA DART AEROSPACE

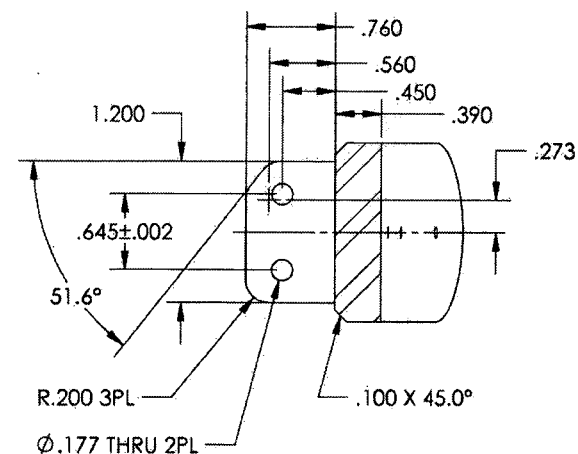
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SHEET	CAGE CODE	DWG. NO.	REV.
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SCALE NONE		SHEET 7 OF 10	

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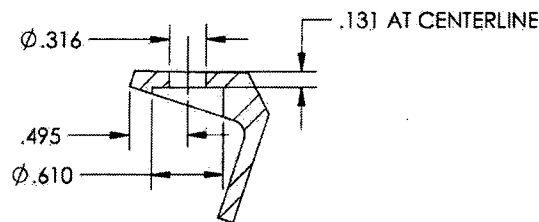
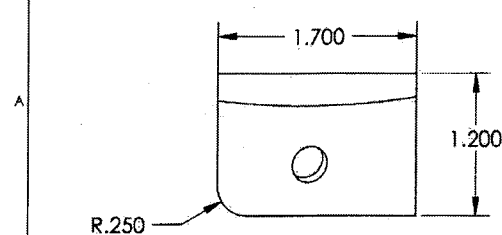
SECTION G-G



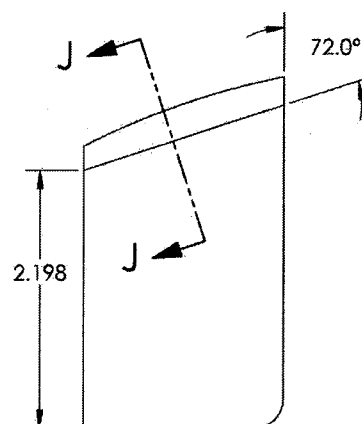
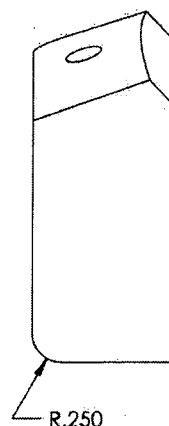
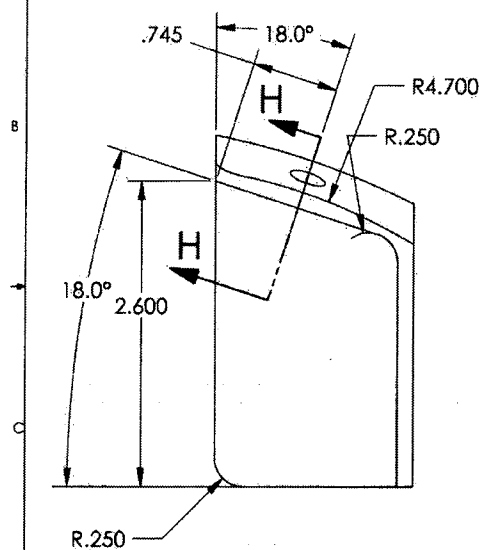
SECTION F-F

ORIGINAL DATE 11-05-09	DART 3030 ENTERPRISE CT., AEROSPACE VISTA, CA 92081 APICAL INDUSTRIES INC. (760)-724-5300 DSA DART AEROSPACE		
DRAWN BY C. ANDERSON	SHEET A		
DESIGNED BY P. BRAVO	BRACKET		
DATE 11-05-09	REV. A		
CONTRACT NO.	647.7800		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°	REV. B	DATE 07/1/26	SCALE NONE
SHEET 8 OF 10			

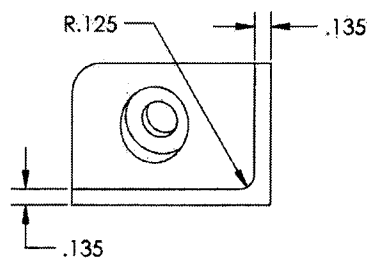
THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.



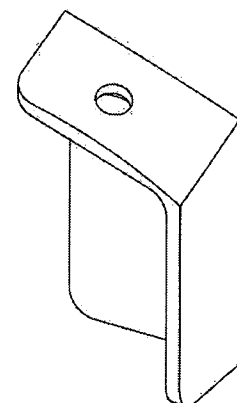
SECTION H-H



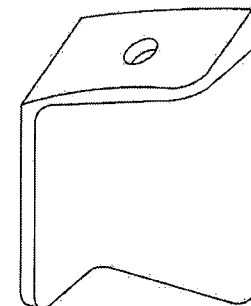
SECTION J-J



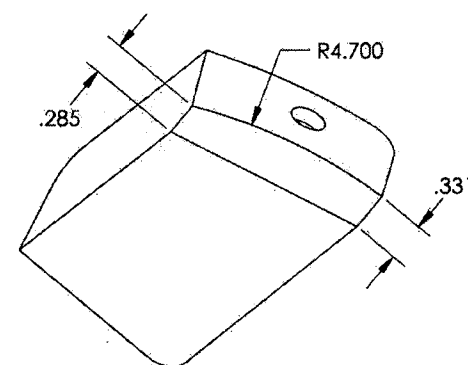
647.7821 SHOWN
647.7822 OPPOSITE



647.7821



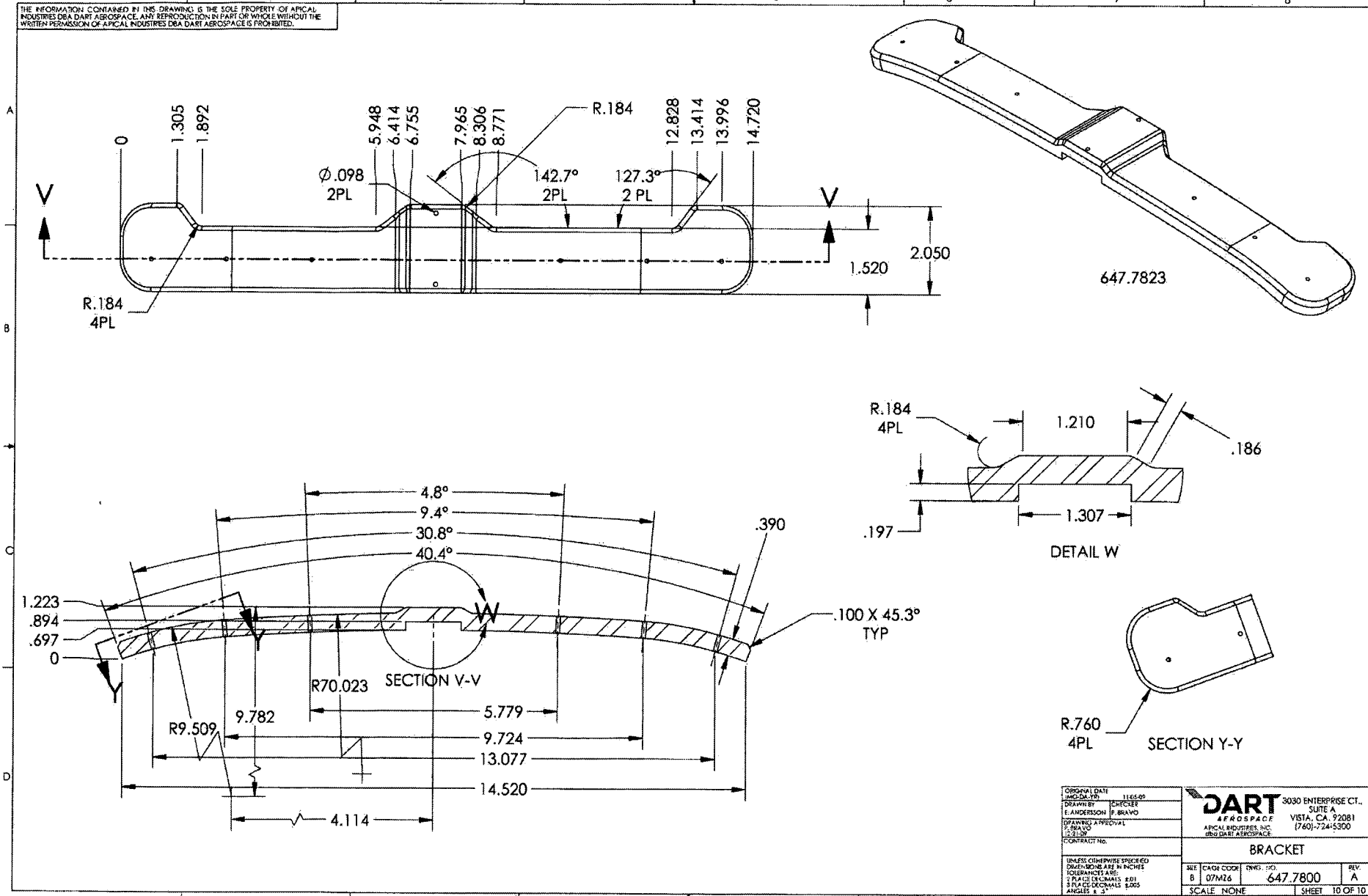
647.7822



SECTION K-K

ORIGINAL DATE 11/01/00		3030 ENTERPRISE CT., SUITE A	
DRAWN BY E. ANDERSON		VISTA, CA. 92081	
CHECKED BY P. BRAYO		(760)-724-5300	
DRAWING APPROVAL P. BRAYO		APICAL INDUSTRIES, INC. dba DART AEROSPACE	
CONTRACT NO.		BRACKET	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: C. PLACE DECIMALS .001 D. PLACE DECIMALS .0005 ANGLES ± .5°	SHEET B	CAGE CODE D7M26	DWG. NO. 647.7800
		SCALE: NONE	REV. A
			SHEET 9 OF 10

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.



ORIGINAL DATE 3-11-89		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY E. ANDERSON	CHECKED BY P. BRAVO	DART AEROSPACE APICAL INDUSTRIES INC. (DBA DART AEROSPACE)	
DESIGNED BY P. BRAVO		REV. 10 OF 10	
CONTRACT NO.		647.7800	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.010 2 PLACE DECIMALS ±.005 ANGLES ±.5°		SCALE NONE	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32971

Purchase Order Date 7/8/2016

PO Print Date 7/13/2016

Page Number 3 of 5

Order From :

VC-ATG001

Ship To : DART AEROSPACE LTD

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-446-4544

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

VENDOR'S TRUCK

Buyer

Customer POID

Customer Tax #

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

FCA - (Free Carrier)

Line Total: \$43.20

7 147215

647.7813 CENTER
PLATE REV. A

7/18/2016

Yes

7/18/2016

10.00

\$8.75

\$87.50

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total: \$87.50

8 142634

646.3717 DOUBLER
REV. A

7/18/2016

Yes

7/18/2016

16.00

\$6.25

\$100.00

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total: \$100.00

9 147714

D4973-1 UPPER
CUTTER REV. C

7/18/2016

Yes

7/18/2016

2.00

\$12.05

\$24.10

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Note:

7/13/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 911973

Date: 18-Jul-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		BEST WAY	
Quantity	Description		
4 ea	Part: D4974-1 UPPER RAIL Job: 19788	Rev: D PO: PO32971	Line: 6
10 ea	Part: 647.7813 ✓ CENTER PLATE Job: 19789	Rev: A PO: PO32971	Line: 7
16 ea	Part: 646.3717 DOUBLER Job: 19790	Rev: A PO: PO32971	Line: 8
2 ea	Part: D4973-1 UPPER CUTTER Job: 19791	Rev: C PO: PO32971	Line: 9
DATE: 18/7/16			
CERTIFIED SIGNATURE:			
RECEIVER SIGNATURE: _____			
Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
CERTIFICATE OF CONFORMANCE			
A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.			
MADE IN CANADA.			